

Date: Wednesday, 1/18/2006 4:06:23 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP WELDMENT
Job Number :	25558A		
Estimate Number :	10176		
P.O. Number :	N/A	Part Number :	D2563
This Issue :	1/18/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2563 REV C
First Issue :	N/A	Project Number :	N/A
Previous Run :	25386A	Drawing Revision :	C
		Material :	N/A
Written By :	SEE COMMENT BELOW	Due Date :	2/15/2006
Checked & Approved By :	SEE ABOVE USER & DATE	Qty:	8
Comment :	Est Rev:G 02.07.31 Re-format Location RF	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D2244116	Step Extrusion
-----	----------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: 320457

1.0 06.02.9 = 8

2.0	D267334	End Plate
-----	---------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2673-34	End Cap

Batch

324279 = 8

325396 = 8

2.0 06.02.9 = 8

3.0	D2561	Lug Plate
-----	-------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2561	Lug Plate

Batch

B25028

3.0 06.02.9 = 8

4.0	D2564	Mounting Angle
-----	-------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2564	Mounting Angle

Batch

B23452

4.0 06.02.9 = 8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:06:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 25558A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

2-Deburr ends

3-Inspect for foreign object per QSI 024

4-Weld as per Dwg D2563 using DT 8343

5-Grind

1h 06.02.9=8

1h 06.02.9=~~10~~8

1h 06.02.9=~~10~~8

1h 06.02.9=~~10~~8

FF 06.02.14=~~10~~8

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06.02.15
06/02/15

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/02/19 8

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/03/07 8

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

Q.M. 06-03-08

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06 03 08 (8)

11.0

DC

DOCUMENT CONTROL



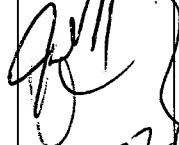

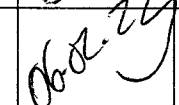
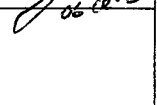

Comment: DOCUMENT CONTROL


Inspection Level 21

06/03/13 (8)

11 06.03.10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.02.22	7B	Pick endplate & deburr for welding	FF	06.02.22	8			
06.02.22	7C	weld endplate as per dwg 02563 - QSI 004	FF	06.02.22	8			
06.02.22	7D	grind endplate flush as per dwg 02563 QSI 004	FF	06.02.22	8			
06.02.22	7E	inspect work to current STEP QC 5/9 106000/10	PD	06.02.22	8			
06.02.22	7F	chemical conversion coat end plate on step as per QSI 0054.1	FF	06.02.22	8			
ADD TO 3.PP / permanent change. 								

ADD TO 2.PP / permanent change. 

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/22
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

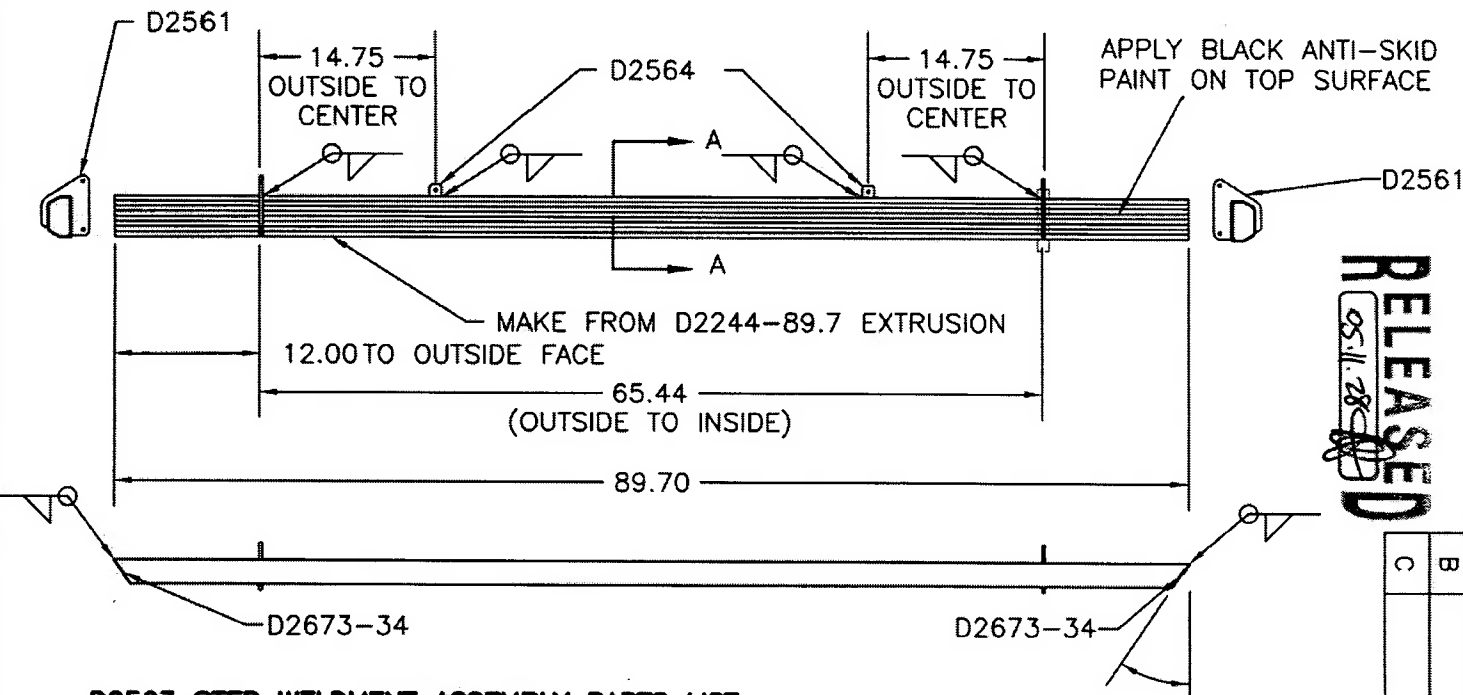
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

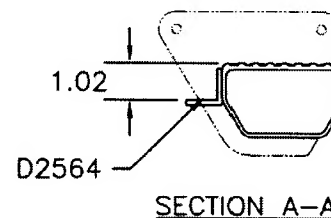
RELEASED
05.11.28



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	44	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
44	44	D2563
DATE	TITLE	SCALE
05.11.14	STEP WELDMENT ASSEMBLY	1:15
A	96.04.26	NEW ISSUE
B	97.05.14	END CAPS CHANGED (WAS D2248)
C	05.11.14	UPDATE NOTES